

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023285**Date Inspected:** 30-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

Trial Assembly / OBG segment 12CW

This QA inspector performed Magnetic Particle Testing (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated MT report for this date. The member is identified as OBG 12CW welds as per ZPMC notification # 08993.

The weld designations reviewed are as follows:

BP3025-001-032~035, 042, 043

BP3025-001-032, 033, 042, 043

BP3025-001-032, 033, 040~043

Trial Assembly / OBG segment 13AE

This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated UT report for this date. The member is identified as OBG 13AE welds as per ZPMC notification # 08995.

The weld designations reviewed are as follows:

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SEG3007C-326

SEG3007E-172, 173

Trial Assembly / OBG segment 14E

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of weld # SEG3019A-022. The welder is identified as 037723. Quality Control (QC) is identified as Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-TC-U4b-FCM-1. See attached photograph Pic_001.

Trial Assembly / OBG segment 14E

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2G position of weld # SEG3019M-021. The welder is identified as 055564. Quality Control (QC) is identified as Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS- B-T-2232-ESAB.

Trial Assembly / OBG segment 14E

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of repair weld # SEG3019AL-022, as per B-WR # 20235. The welder is identified as 215553. Quality Control (QC) is identified as Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-FCM-Repair.

Trial Assembly / OBG segment 13AW

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 3G position of weld # SEG3013N-217. The welder is identified as 201215. Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS- B-T-2233-ESAB.

Trial Assembly / OBG segment 14W

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of weld # SEG3020AH-003. The welder is identified as 066674. Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-TC-U4b-FCM-1.

Trial Assembly / OBG segment 14W

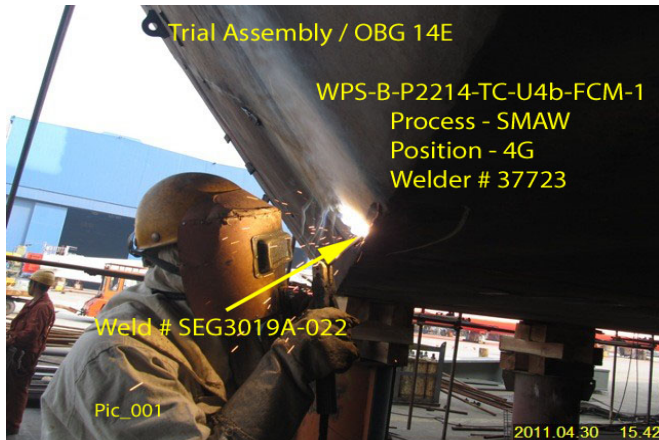
This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of weld # SEG3020AH-0043. The welder is identified as 067520. Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

with WPS-B-P-2212-TC-U4b-FCM-1.



Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey (+86) 15000026784 , who represents the Office of Structural Materials for your project.

| | | |
|----------------------|-------------------|-----------------------------|
| Inspected By: | Gade,Ramesh | Quality Assurance Inspector |
| Reviewed By: | McClendon,Timothy | QA Reviewer |
